

ABSTRACT

A method of a double starwheel unit in multiple rows with a multi-hole manner, an instrument and the like. The double starwheel unit has a sleeve and two starwheel parallel-arranged and connecting the sleeve. The 5 instrument has a plate-like assembly fixture and an orientation mechanism. The plate-like assembly fixture has a plurality of strip-like tools. The method combines the strip-like tools with the plate-like assembly fixture and a plurality of module holes, presses an exterior mold on the starwheel onto upper and lower surfaces of the plate-like assembly fixture, and injects a working fluid to 10 shape the double starwheel units. The strip-like tools are engaged or disengaged by the orientation mechanism.